

# Work Order ID 51391

August 20, 2009 3:38:10 PM



Page 1

Item ID: D3558-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gasket

Start Date: 08/24/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-08-20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3558

Rev B

12

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3558 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 12-  
Deburr if necessary

HB 9-8-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-8-27

12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8086867

HB 9-8-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3558-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gasket

Start Date: 08/24/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 08/28/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location

FPB

0.00

Memo

0.00

9/8/09

124

SP

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/09

BP 09-8-25 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 51391

Parent Item: D3558-3RevB

Parent Item Name: Gasket

Comments:

Start Date: 08/24/2009

Required Date: 08/28/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	239.6994	9.5015			
NEOPRENE SHEET 0.063												

B 9-8-07

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	239.6993585	
111469	71.1	
111853	168.599359	

111853

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51391
<b>Description:</b> Gasket		<b>Part Number:</b> D3558-3
<b>Inspection Dwg:</b> D3558	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.189	*			
0.30	+/-0.030	.300	*			
0.30	+/-0.030	.301	*			
0.38	+/-0.030	.381	*			
2.73	+/-0.030	2.733	*			
2.06	+/-0.030	2.064	*			
5.63	+/-0.030	5.635	*			
33.75	+/-0.030	33.75	✓			
36.13	+/-0.030	36.13	x			

<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-8-27	<b>Date:</b> 02/08/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	08.04.17	Dimensions updated per Dwg Rev B	KJ/DD	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

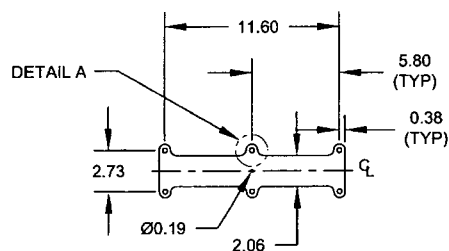
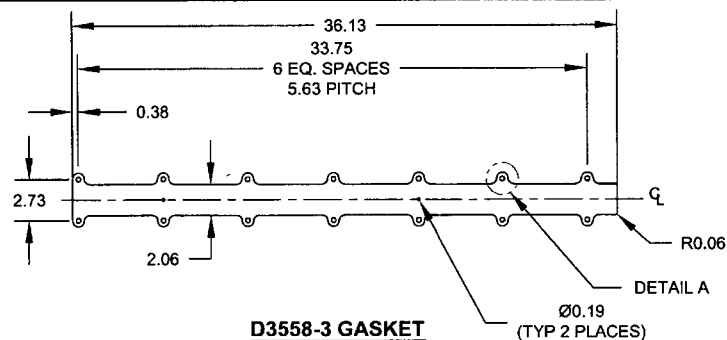
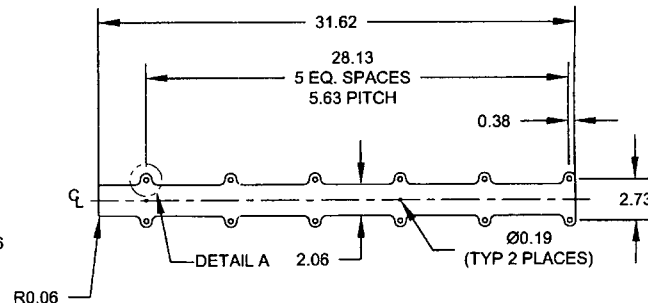
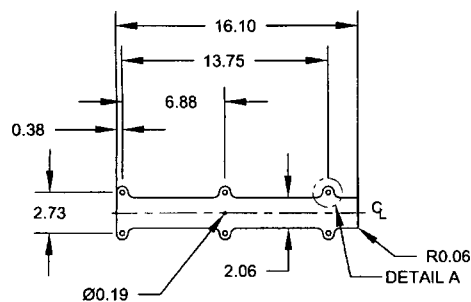
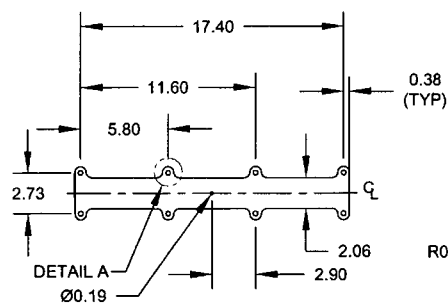
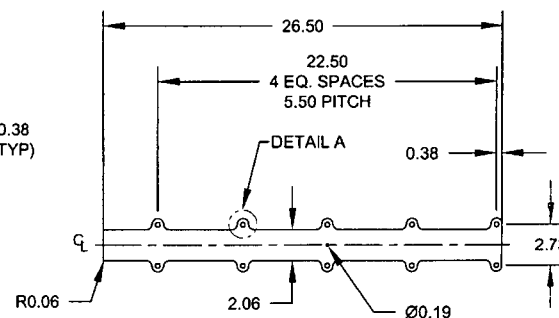
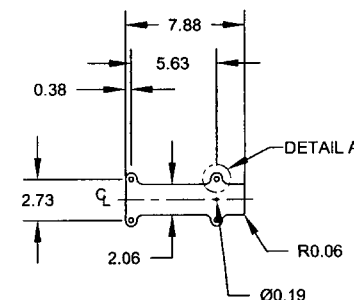
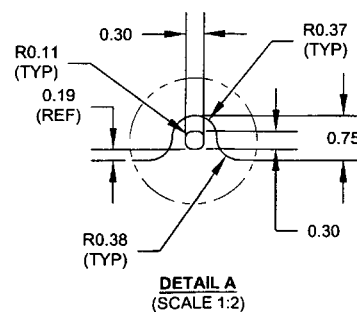
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#51391

**D3558-1 GASKET****D3558-3 GASKET****D3558-5 GASKET****D3558-7 GASKET****D3558-9 GASKET****D3558-11 GASKET****D3558-13 GASKET****DETAIL A  
(SCALE 1:2)****NOTES:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF. DART SPEC. M-NEW60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3558-1 - 0.09 lbs, D3558-3 - 0.26 lbs, D3558-5 - 0.23 lbs, D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs, D3558-13 - 0.06 lbs

#51391  
MF  
07-08-20RELEASED  
07-11-16

B	ADD -9/-11/-13 UPDATE DRAWING FORMAT	PH	07.04.20
A	NEW ISSUE	PH	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3558	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GASKET	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

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